

Date: Tuesday, 07/04/2009 10:35:11 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PANEL-350 UPPER BULKHEAD
<b>Job Number</b> : 47020	
<b>Estimate Number</b> : 13100	
<b>P.O. Number</b> :	<b>Part Number</b> : D36553
<b>This Issue</b> : 07/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3655 UNDER REVIEW <i>in 07/04/08</i>
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : 00204
<b>First Issue</b> : / / <b>Type</b> : THERMOFORMING	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 46879	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 24/04/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.04.07</u>	
<b>Comment</b> : Est. Rev. A 07/12/13 New Issue DL verified by:DD Est. Rev. B 08/09/25 Dwg. Update DL.	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
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**Comment:** Qty.: 34.6600 sf(s)/Unit Total : 138.6400 sf(s)  
 GE PLASTICS LEXAN SHEET  
 batch: M10757Y

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

*BB 09/04/07 XY*

3.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3655-3 and Folio FTA 017 using tool DT 8985

Dwg. Rev. B

Folio Rev. A

*BB 09/04/08 XY*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

*BB 09/04/08 XY*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 07/04/2009 10:35:11 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 UPPER BULKHEAD

Job Number: 47020

Part Number: D36553

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 02/04/14 (X4)

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3655

BB 09/04/14 (X4)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/04/14 (X4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/14 (X4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST/ST 09/04/15 (4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/16

Job Completion



U 09.04.15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 47020
Description: 350 UPPER BULKHEAD		Part Number: D36SS3
Inspection Dwg: D36SS Rev: 3		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/04/13

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30.25	+0 - .10	30.20	✓			
44.5		44.5	✓			
67.9		67.925	✓			
.050		.053	✓			
.070		.089	✓			

Measured by: BB

Date: 09/04/13

Audited by: E

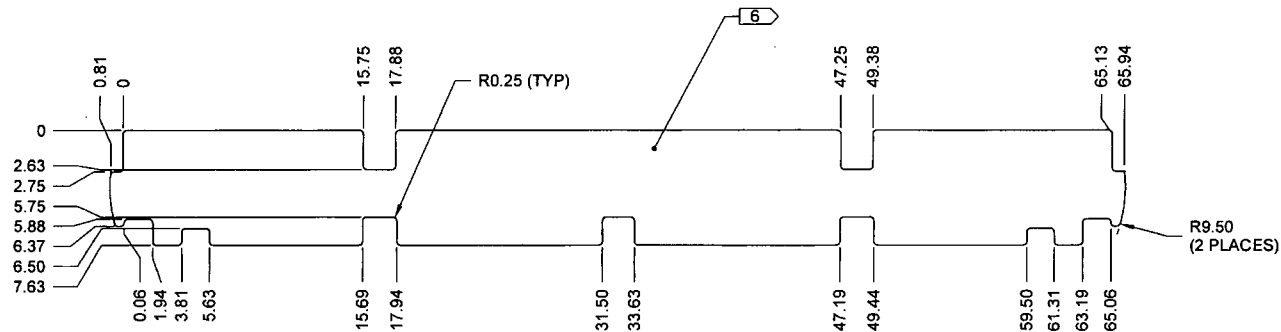
Date: 09/04/14

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

Handwritten signature/initials.



**D3655-1 PANEL**

**RELEASED**  
08.07.30.14

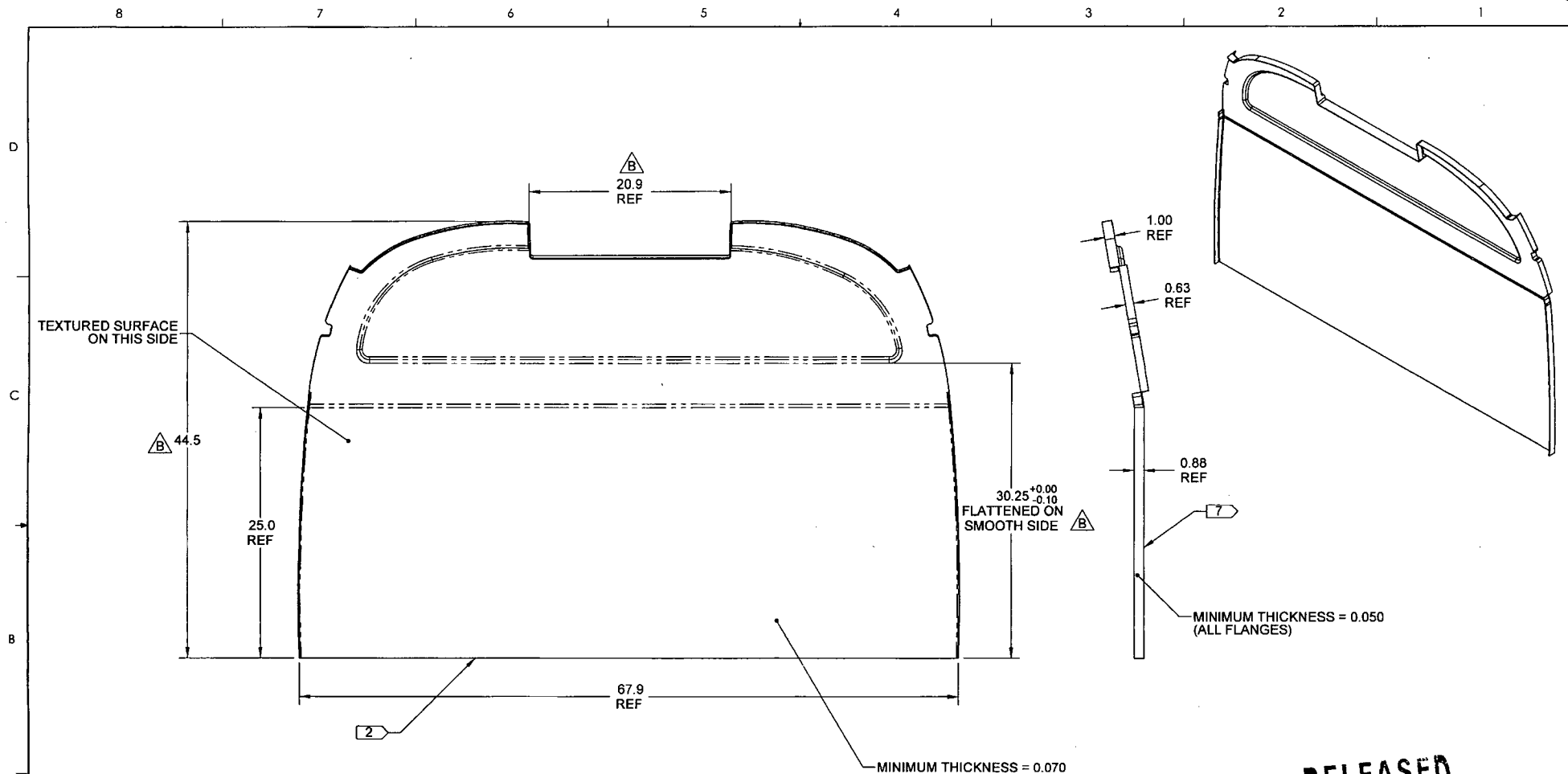
**D3655-1 NOTES:**

1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
(REF DART SPEC MLEXS.093-F6006-07)

2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) SURFACE FINISH: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: P/N AND B/N ON SMOOTH SIDE OF PART  
7) MARKING: 88

NO. 17000  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

B	44.5 WAS 45.5 (ZN C8-2); 20.9 WAS 19.9 (ZN D5-2); DELETE REFERENCE DIMENSION 2.4 (ZN D6-2); ADD 30.25 DIMENSION FOR TRIMMING (ZN C3-2); REASON: DRAFTING ERROR	PH	08.06.16
A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JE	DRAWING NO.	REV. B
CHECKED	JE	D3655	SHEET 1 OF 2
MFG. APPR.	JE	TITLE	SCALE
APPROVED	JE	PANEL	NTS
DE APPR.	JE	DATE 08.06.16	
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**D3655-3 PANEL**

**RELEASED**  
08-09-30-17

**D3655-3 NOTES:**

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8985 PER QSI 022 TRIM PER MOLD DT8985 EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: DART P/N AND B/N ON SMOOTH SIDE OF PART

DESIGN	CE	<b>DART AEROSPACE LTD</b>	
DRAWN	1/24	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3655	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
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